

Date: Thursday, 25/01/2007 8:35:30 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 30447		
Estimate Number	: 10498		
P.O. Number	: N/A	Part Number	: D2739
This Issue	: 25/01/2007 S.O. No. : N/A	Drawing Number	: D2739 REV C
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 29997	Material	: N/A
Written By	:	Due Date	: 01/02/2007 Qty: 4 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: 02.11.28 Rerformat KJ Est Rev: D 06-03-21 As Per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
		 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web <i>B24410</i> <i>for 001-26</i> <i>(5)</i> <i>PTO</i>
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1  <i>DP/JD 7-1-25</i>
3.0	QC5	INSPECT WORK TO CURRENT STEP  Comment: INSPECT WORK TO CURRENT STEP <i>DP 7-1-25</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/02/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-25	20	1 hole @ the FWD location between the saddle holes (the 1" Ø) was drilled back very uneven, not round, caused by the unibit. Hole is oversized by .005 when corrected with a deburring tool.	<input checked="" type="checkbox"/> 05/04/2	Web unacceptable. Scrap, destroy, replace.	JD DP 7-1-25	<input checked="" type="checkbox"/> 07/02/06	<input checked="" type="checkbox"/> 05/04/2	<input checked="" type="checkbox"/> 07-01-25
7-1-25	2.	① Waha out of Tolerance By +.100, short. At the Fwd side. Human error.	<input checked="" type="checkbox"/> 05/04/2	Acceptable. Ensure employee verifies measurement before cutting.	JD DP 7-1-25	<input checked="" type="checkbox"/> 07-02-06	<input checked="" type="checkbox"/> 05/04/2	<input checked="" type="checkbox"/> 07-01-25

NOTE: Date & initial all entries

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4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BE 15b 7-1-25 (4)

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock  
Location: 16

Pm 07-01-26 (4)

7.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

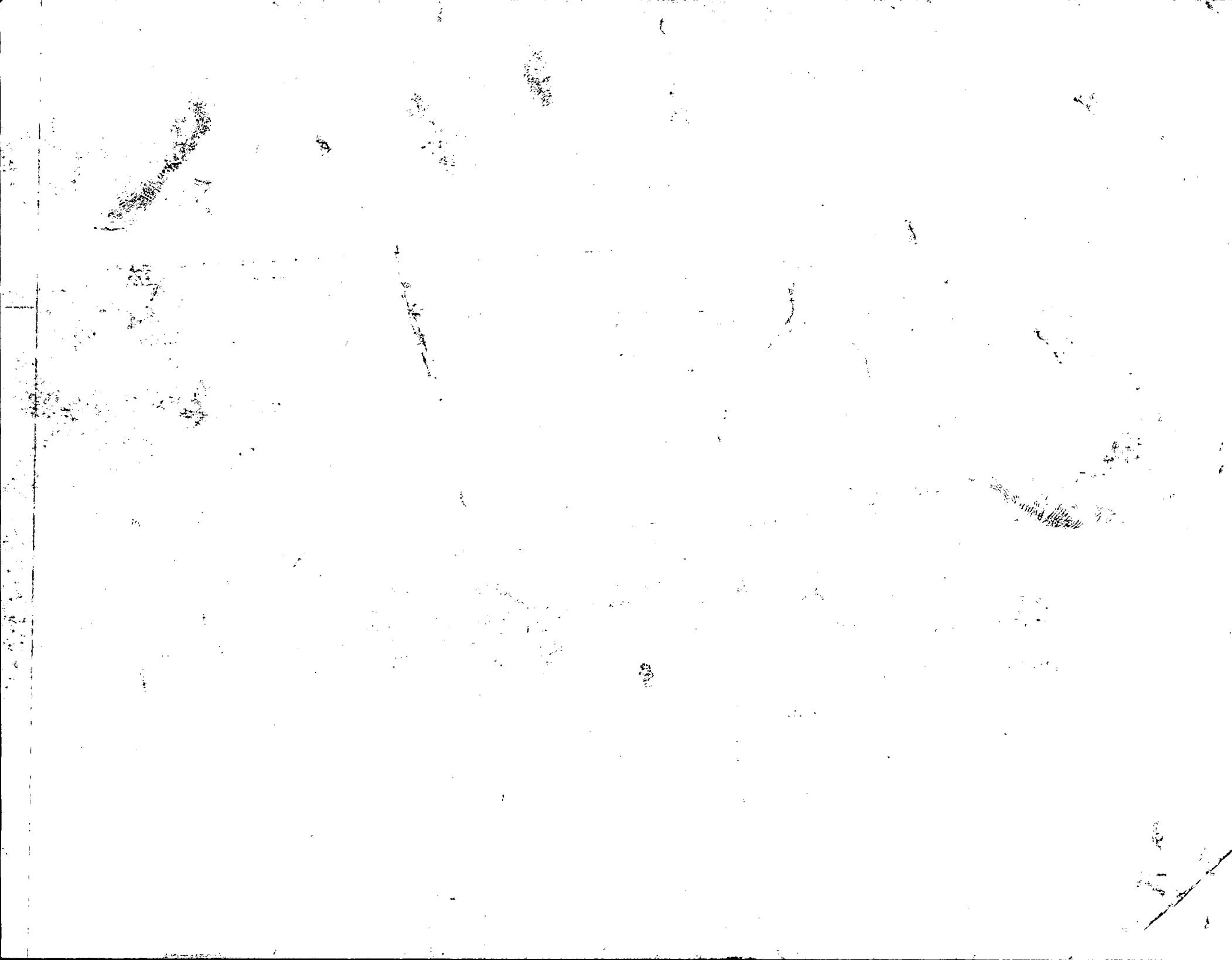


(4)  
07/02/06

Job Completion



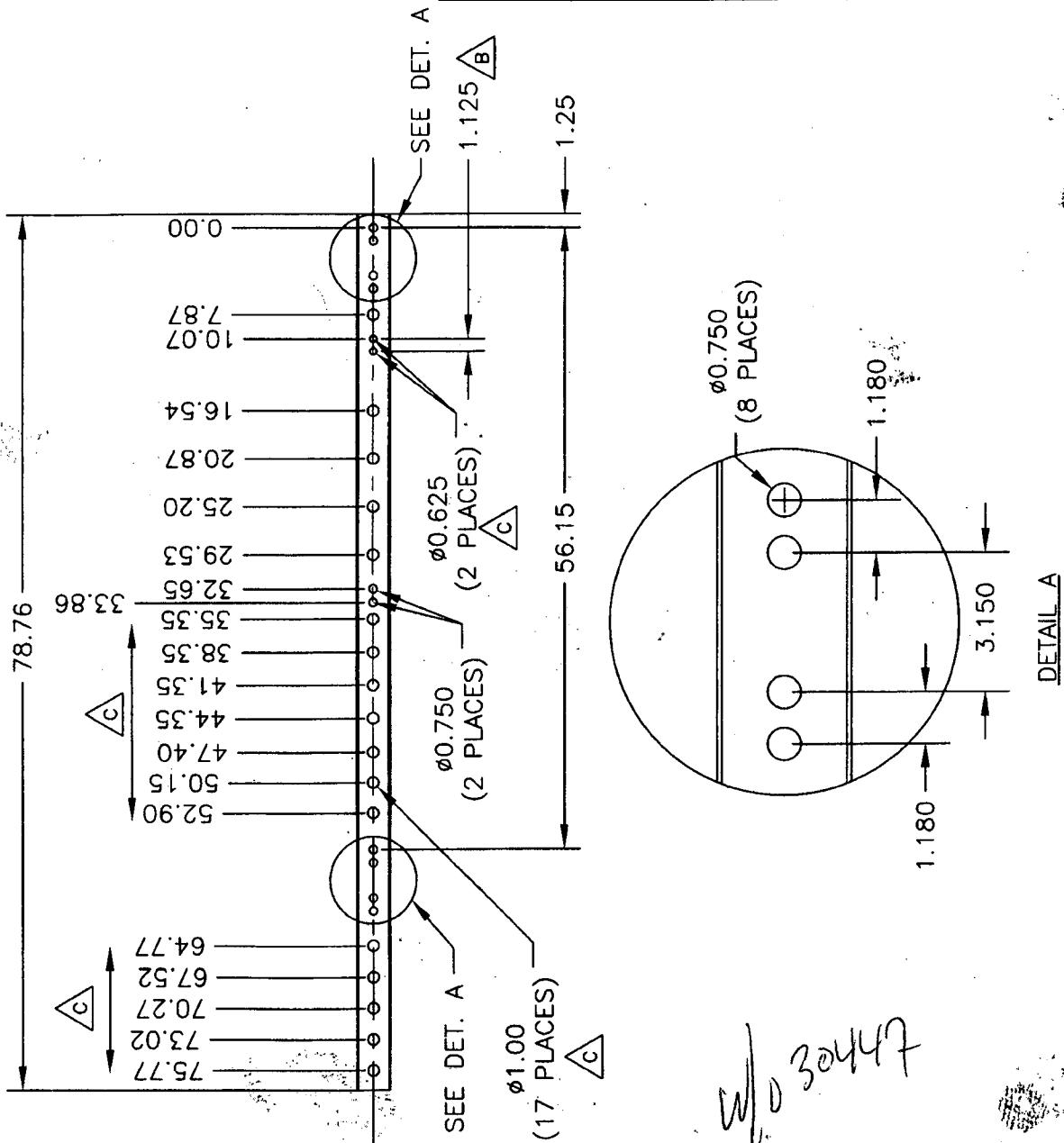
U Avord



**DART**

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2739	REV: C SHEET 1 OF 1	
DATE 06.01.05		TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE		
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS		
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS		

**RELEASED**  
de-02-07 *[Signature]*



D2739 WEB  
1) MATERIAL  
2) FINISH:  
3) ALL DIM  
4) TOLERANCE

MAKE FROM D2600-5 EXTRUSION  
ACID ETCH, ALODINE PER DART QS  
S ARE IN INCHES  
RE PER DART QS 018 UNLESS OT

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